

Date: Tuesday, 4/17/2007 3:09:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP (CASTING DETAIL)
Job Number : 31940	
Estimate Number : 11088	
P.O. Number : <i>N/A</i>	Part Number : D25761
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2576 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : E1
Previous Run : 29514	Material : <i>N/A</i>
Written By : _____	Due Date : 4/30/2007 Qty: 100 Um: Each
Checked & Approved By : <i>07.04.17</i>	
Comment : Est Rev: A New Issue 05-11-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *3574*

Ship D2576 mould to vendor

Cast per D2576-1 Pattern

Material Release Note Required

*C 7/104/18**(100)*

2.0	D25761P	Step (Casting Detail)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

STEP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure D2576 mould is returned with the ordered parts

Ensure release note is attached

*C 7/15/01**(106)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

*07.05.02 106**QSP09*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

*C 7/15/02**(106)**CNC*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:09:05 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 31940

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



106

Comment: FINAL INSPECTION/W/O RELEASE

07/05/02

Job Completion



U 07-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

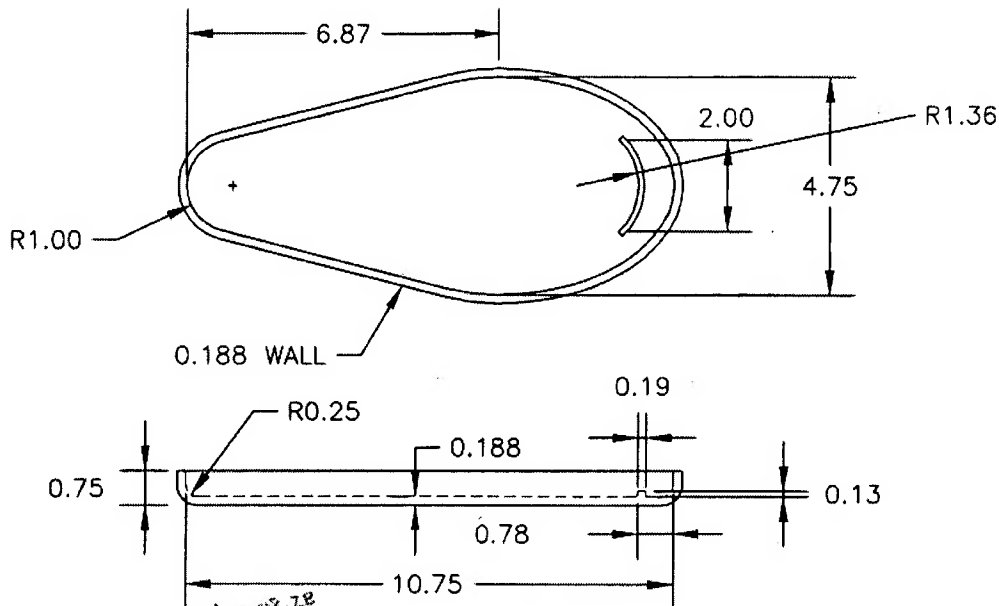


DESIGN PH	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED KE	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
E1	RF 03.04.29	7.05 WAS 6.61	

RELEASED
99.09.08 DS

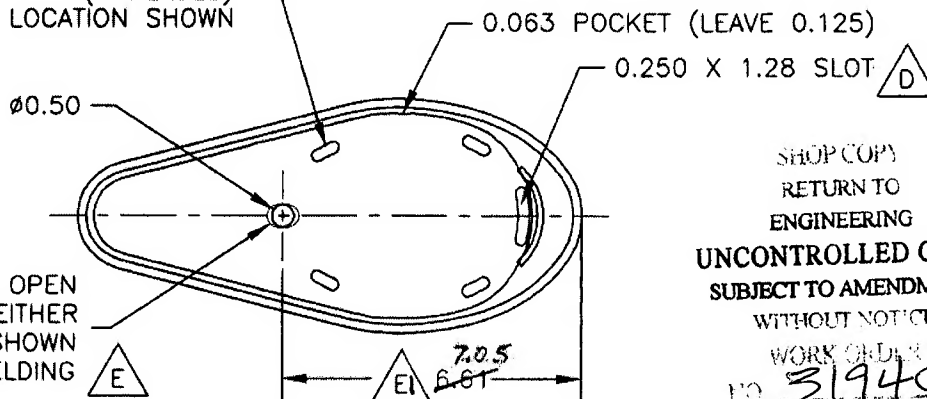
CASTING DETAIL (D2576-1) *UP 08.28*

MATERIAL: CAST ALUMINUM ALLOY A-535.2
BREAK SHARP EDGES 0.025 TO 0.050
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) *UP 08.28*

$\triangle D$ 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN



IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING $\triangle E$

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31940

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA**Ship To: DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via			Page
18-Apr-2007		PO00003574	03-May-2007	FEDEX			1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ship	
1	DART D2576	D2576 STEP CSTG		100		106	
2							

Comments

Castings&Patterns are property of Alpine until paid in full

Apr. 30/07

YAAG6